¹lser Customer Job Number **Estimate Number** This Issue Prsht Rev. First Issue **Previous Run** Written By Comment

Thursday, 22/05/2008 1:44:14 PM

Julie Lecocq

Process Sheet

: CU-DAR001 Dart Helicopters Services

: 39424A

: 12129

P.O. Number

: 22/05/2008

: NC

: // : 37627A

Type

S.O. No. :

: LARGE FAB ASSY

Part Number

Drawing Name

: D412729041 : DSK 092 REV B

: GHW MEDIUM BELL

Drawing Number Project Number

: N/A

Drawing Revision

Material

: 15/06/2008

Due Date

Qty:

2 Um:

Each

Checked & Approved By

: Est Rev:E 05.04.13

LPS3 rust inhibitor added; Hardware P/N's

KJ/JLM changed

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

DC 1.0

DOCUMENT CONTROL

Comment: DOCUMENT CONTROL

If D412-729-041 is a W/O on it's own,

Photocopy bluefile and create labels per PPP D412-729-041 CHG003

2.0

D27287



Label

Comment: Qtv.:

Total: 1.0000 Each(s)/Unit

2.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2728-7 Label

Wheel Assembly

3.0

D3233041



2.0000 Each(s)/Unit

Description

Total:

4.0000 Each(s)

Comment: Qty.:

Pick: **Qty Part Number**

4.0

D32331

Inside Washer

Comment: Qty.:

2.0000 Each(s)/Unit Total:

2 D3233-041 Wheel Assembly

4.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 D3233-1 Inside Washer 317

Form: rprocess

Dart Aerospace Ltd

W/O:	,	WORK ORDER CHANGES									
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
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Part No		PAP #: Fault Category:	NCP: Voc	No DO	.	Data					

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NCR:		WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC		Corrective Action Section B			Ammuoval			
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Customer	· CLLDAROO1	Dart Helicopters Services		rawing Name: GHV	W MEDIUM BELL	
Customer	. 00-07(00)	Dait Honoopters Services	J.	anning rannor or re		
Job Number	: 39424A			Part Number: D41	2729041	
Job Number:			-			
Seq. #:	Machine O	r Operation:		Descrip	tion :	
5.0	D32333	1 BILL 118111 BBIL 1881	Outside Washer		118911188	
/						
Comm	ent: Qty.: Pick:	2.0000 Each(s)/Unit Tota	d: 4.0000 Each(s)			
•		Number Description	Batch			
	2 D32	33-3 Outside Washer	5/074		8/6/13	SØ
6.0	D33091		Label		1 1 1 1 1 1 1 1 1 1	
/						
Comm	•	1.0000 Each(s)/Unit Total	I: 2.0000 Each(s)			
	Pick: Oty Part	Number Description	Batch			
	-	09-1 Label 370	18		8/6/13	<0
				-	016183	ΣΨ
7.0	D33093		Label			
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Comm	ent: Qty.: Pick:	2.0000 Each(s)/Unit Teta	4.0000 Each(s)	\bigcirc		
		Number Description	Batch 50	3017	,	
	2 D33	09-3 Label <u>ろしげ</u>	<u>子</u> うり	(1)	8/6/13	50
8.0	D3330041		Frame Weldme	nt	111111111111111111111111111111111111111	
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Comm	ent: Qty.:	1.0000 Each(s)/Unit Tota	II: 2.0000 Each(s)			
WA	Pick:	N. I December	Datah			·
	G(t) i dit	Number Description 30-041 Frame Weldment	3944G		9/1/12	S 0
			t to a dia A a a sub	h.	0/6/13	<u> </u>
9.0	D3331041		Handle Assemb	пу	/ '	
1						(22)
Comm	•	1.0000 Each(s)/Unit Total	l: 2.0000 Each(s)			
	Pick: Qty Part	Number Description	Batch —			
		31-041 Handle Assembly	37082		0.10	Cla
					8/6/13	<i>SU</i>
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W/O:		WORK ORDER CHANGE	HANGES					
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Part No:	PAR #:	Fault Category:	NCR: Yes N	DQA:	Date:
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		Description of NC		Corrective Action Section B	Verification	Approval	Approval				
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector			
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Thursday, 22/05/2008 1:44:14 PM Date: User: Julie Lecocq **Process Sheet** Drawing Name: GHW MEDIUM BELL Customer: CU-DAR001 Dart Helicopters Services Part Number: D412729041 Job Number: 39424A Job Number: Description: Seq. #: **Machine Or Operation:** D3332041 Pin Assembly 10.0 1.0000 Each(s)/Unit Total: 2.0000 Each(s) Comment: Qty.: Pick: 8/6/13 D3332043 Pin Assembly 11.0 Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s) Pick: 8/6/13 **Qty Part Number** Description Batch 1 D3332-043 Short Pin Assembly 12.0 D33331 2.0000 Each(s) Comment: Qty.: 1.0000 Each(s)/Unit Total: Pick: Qty Part Number Description Batch 1 D3333-1 Base Plate 15/50 8/6/13 Sliding Plate D33333 13.0 Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s) Pick: Description Batch Qty Part Number 1 D3333-3 Sliding Plate 14.0 D33335 4.0000 Each(s)/Unit Total: 8.0000 Each(s) Comment: Qty.: Pick: **Qty Part Number** 4 D3333-5 Rail

Dart A	erospace	Ltd
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W/O: WORK ORDER CHANGES								
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Date: User:		Lecocq	2006 1.44; 14 PW	Proce	ess Sheet		
Cu	stomer:	CU-DAR001	Dart Helicopters Servi	ces	Drawing Name: GH	W MEDIUM BELL	
Job N	lumber:	39424A			Part Number: D4	12729041	
Job Numi	ber:						
					D	41	
Seq. # :	.0	Machine O D33341	r Operation:	Wheel S	Descrip naft	otion :	<u></u>
\V.	Comme	nt: Qty.: Pick:	2.0000 Each(s)/Unit	Total: 4.0000 Ea	ch(s)		
*			-	tion Batch 34795:	37785	8/413	SO
16.	.0	D33351		Short Sp	ring		
<u> </u>	Comme	nt: Qty.:	1.0000 Each(s)/Unit	Total : 2.0000 Ea	ch(s)	110111101111111111111111111111111111111	
		Pick: Oty Part	Number Descrip	tion Batch		a / /	
	-	1 D33		25925		8/6/13	50
17.	.0	D33353		Long Spi	ing		
:	Comme	nt: Qty.: Pick:	1.0000 Each(s)/Unit	Total: 2.0000 Ea	ch(s)		
		Qty Part 1 D33	-	tion Batch 707	3945	9/6/13	Se
18.	.0	D33361	.	Jack			
	Comme	nt: Qty.: Pick:	1.0000 Each(s)/Unit	Total: 2.0000 Ea	ch(s)		
		Qty Part		tion Batch			
		1 D33	36-1 Jack	152,108		8/6/13	SØ
19.	0	AN960JD416		Washer			(7x)
V	Comme	nt: Qty.:	2.0000 Each(s)/Unit	Total: 4.0000 Ea	ch(s)	1 (6611) 4411 (441)	
		Pick: Qty Part	Number Descrip	tion Batch		11	
		•	60JD416 Washer_		8	16/13	50

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W/O:		WORK ORDER	WORK ORDER CHANGES								
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)									
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Thursday, 22/05/2008 1:44:14 PM Date: User: Julie Lecoca **Process Sheet** Drawing Name: GHW MEDIUM BELL Customer: CU-DAR001 Dart Helicopters Services Part Number: D412729041 Job Number: 39424A Job Number: Description: Seq. #: Machine Or Operation: 1/8" Cotter Pin 2" long CP21 20.0 2.0000 Each(s)/Unit Total: 4.0000 Each(s) Comment: Qty.: Pick: Qty Part Number Description Batch 2 CP-21 1/8" Cotter Pin 2" long, Span HC12 21.0 1.0000 Each(s)/Unit Total: 2.0000 Each(s) Comment: Qty.: Pick: **Qty Part Number** Description Batch 1 HC-12 1/4"-20 UNC x 1" long Hex Bolt, Span 8/6/13 22.0 HC29 5/16-18 UNCx1.5 Hex Bolt 16.0000 Each(s)/Unit Total: 32.0000 Each(s) Comment: Qty.: Pick: 107524 3/6/13 Qty Part Number Description Batch 16 HC-29 5/16"-18 UNC x 1.5" long Hex Bolt, Prof 3/8"-24UNFx1.25 Hex Bolt 23.0 HC153 8.0000 Each(s)/Unit Total: 16.0000 Each(s) Comment: Qty.: Pick: Description Batch Qty Part Number 8 HC-1533/8"-24 UNF x 1.25" long Hex Bolt, Span 107031 HN120 HEX SLOTTED NUT 24.0 Comment: Qty.: 4.0000 Each(s) 2.0000 Each(s)/Unit Total: Pick: **Qty Part Number** Description 8/6/12 2 HN-1201" Slotted Nut, Prof 101

Dart Aerospace Ltd

W/O:			WORK ORDER CHANGES									
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User: Juli	ursday, 22/05/ ie Lecocq	i/2008 1:44:14 PM Process Sheet		
, , , , , , , , , , , , , , , , , , , ,			HW MEDIUM BELL	
Customer	: CU-DAROU	11 Dart Helicopters Services Drawing Name: G	• • • • • • • • • • • • • • • • • • •	
Job Number:	: 39424A	Part Number: D	·	
Job Number:	·	DE CHIE CHAI DE LE RECLECITE IN THE COLO		
/ Seq. #:	Machine C	Or Operation: Descr	iption :	
25.0	HN177	5/16-18UNC Nylon LockNut		
J '' ;				
Comm	ent: Qty.: Pick:	16.0000 Each(s)/Unit Total: 32.0000 Each(s)	(14)	
	Qty Par	t Number Description Batch	108200	•
	16 HN-	-1775/16"-18 UNC Nylon Lock Nut, Span	8/6/13	SP
26.0	HX15	1/4-20 UNCx3/4 S.H.C.S.	,	
Comm	ent: Qty.: Pick:	2.0000 Each(s)/Unit Total: 4.0000 Each(s)		
	Ot . D	t Number Description Batch		
	2 HX-	-15 1/4"-20 UNC x 3/4" long S.H.C.S., Span	/ /	_
			8/6/13	Sal
27.0	MS21042L5	5 Nut		
/				÷.
Comm	ent: Qty.: Pick:	2.0000 Each(s)/Unit Total : 4.0000 Each(s)		
		t Number Description Batch		
	2 MS	t Number Description Batch 21042L5 Nut (or -5)	8/6/13	50
28.0	2333	1 1/4" Type B Washer		
/				
Comm	ent: Qty.: Pick:	1.0000 Each(s)/Unit Total: 2.0000 Each(s)		
	Qtv Pari	t Number Description Batch		
	1 233	1 1/4" Type B Flat Washer (Wide), Span 102150	8/4/13	SD
29.0	18SNB	3/8" Lock Washer		
				(zx)
Comm	ent: Qty.: Pick:	8.0000 Each(s)/Unit Total: 16.0000 Each(s)		
	Qty Part	t Number Description Batch SNB3/8" Lock Washer, Span 10703/	/ /	_
	8 18-9	SNB3/8" Lock Washer, Span <u>/ 0 / U 3</u> / 8	16/13	54

W/O:		WORK ORDER CHANGES									
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Part No	:	PAR #: Fault Category:	NCR: Yes	No DQ	A:	Date: _					

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DATE STEP	Description of NC		Corrective Action Section B		Verification	Approval		
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Thursday, 22/05/2008 1:44:14 PM Date: User: Julie Lecocq **Process Sheet** Drawing Name: GHW MEDIUM BELL Customer: CU-DAR001 Dart Helicopters Services Part Number: D412729041 Job Number: 39424A ∠ Job Number: Description: Seq. #: **Machine Or Operation:** 1/8" PTF Grease Fitting 113803 30.0 8.0000 Each(s) 4.0000 Each(s)/Unit Total: Comment: Qty.: Pick: Description Batch **Qty Part Number** 2 113-803 1/8" PTF Grease Fitting, Span 1065/2 SS Flat Washer 5/16 516WC 31.0 16.0000 Each(s)/Unit 32.0000 Each(s) Comment: Qty.: Total: Pick: **Description Batch Qty Part Number** LARGE FABRICATION RESOURCE 1 LARGE FAB 1 32.0 16 cs.06.30 Comment: LARGE FABRICATION RESOURCE 1 Assemble as per Dwg DSK 092. Apply LPS3 heavy duty rust inhibitor & corrosion (Procyon). Inflate wheel assembly to 90 psi. Ensure that unit goes up and down smoothly after assembly. Install decals last. INSPECT WORK TO CURRENT STEP 33.0 Comment: INSPECT WORK TO CURRENT STEP PACKAGING RESOURCE #1 **Comment: PACKAGING RESOURCE #1** Identify and Stock Location: FINAL INSPECTION/W/O RELEASE 35.0 Comment: FINAL IN a 08.07.0 Job Completion

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES									
DATE	STEP	STEP PROCEDURE CHANGE By				Approval Chief Eng / Prod Mgr	Approval QC Inspector				
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Part No:	PAR #:	Fault Category:	NCR: Yes No	DQA:	Date:
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_		Description of NC		Corrective Action Section B		Verification	Approval Chief Eng	Approval QC Inspector			
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		1	4		
	DESIGN DRAWN BY		DRAWIN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
	CHECKED		APPROVED	DSK 092 sh	REV. B
					EET 1 OF 1
	DATE			TITLE	SCALE
	05.02.18			HYD. GROUND HANDLING	1:5
	A	04.12.06		NEW ISSUE	
	В	3 05.02.18		REDESIGN TO FIT NEW WHEEL ASS'Y	

D3309-1

LABEL (1)

D3331-041

HEX. SOCKET

CAP SCREW 1/4"-20 x 0.75",

AN960JD416 **FLAT WASHER**

(2 PLACES)

WHEEL ASS'Y

D3336-1 JACK (1)

SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

W3RK,ORDER

D3333-1 BASE PLATE (1)

D3330-19 HANDLE RIM (1)

(2 PLACES)

D3233-041

(2 PLACES)

HANDLE ASS'Y (1)

D3330-17 HANDLE

D2728-7

LABEL (1)

SOCKET (1)

HEX BOLT 1/4"-20 x 1" LONG (1) FLAT WASHER 1/4" TYPE B WIDE (1) D3330-9 TOP PLATE (1) D3330-5 FRONT PANEL (1) D3330-7 BACK PANEL (1) (NOT SHOWN, SIMILAR TO D3330-5) D3330-15 HANDLE (1)-D3309-3 LABEL (2 PLACES) D3333-3 SLIDING PLATE (2 PLACES) D3335-3 LONG SPRING (1) D3330-11 LONG PIN (NOT SHOWN) **BRACKET (1)** D3332-041 LONG PIN ASS'Y (1) **D3233-1 INSIDE** WASHER (2 PLACES) D3233-3 OUTSIDE WASHER (2 PLACES)

> **SLOTTED NUT** 1"-14 UNF AND

> > (2 PLACES)

ROUND COTTER PIN 1/8" x 2" LONG

0 0 0 g D3334-1 WHEEL SHAFT D3330-3 (2 PLACES) BOTTOM-PANEL (1) D3333-5 RAIL (4-PLACES) D3330-1 HEX. BOLT 3/8"-24 UNF x 1.25" LONG REG. SPRING LOCK WASHER 3/8" LEFT PANEL (1) D3332-043 (8 PLACES) SHORT PIN (1) D3330-2 RIGHT HEX. BOLT 5/16"-18 UNC x 1.50" LONG **D3335-1 SHORT** FLAT WASHER TYPE B NARROW 5/16" PANEL (1) SPRING (1) STD. HEX. NYLON LOCK NUT 5/16"-18 UNC (NOT SHOWN) (16 PLACES) D3330-13 SHORT PIN MS21042L5 NUT GREASE FITTING 1/8" P.T.F.

NOTE:

1) APPLY RUST INHIBITOR ON ALL PARTS AND AREAS NOT PROTECTED BY PAINT OR GREASE. RUST INHIBITOR POSSIBLE SUPPLIER: ACKLANDS-GRANGER INC., P/N LPSC30316.

(4 PLACES)

SAE SPEC. EXTRA SHORT

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BRACKET (1)

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